

Work Order ID 67526 -2

Monday, March 28, 2011 9:06:39 AM

Split



Page 1

Item ID: D3319-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearplate

Start Date: 3/28/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 3/31/2011 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals: Process Plan: *H*

Date: 11-03-28 Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3319	Rev B								
100		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3319								
1010 650	Dwg Rev. <u>0</u>								
	Prog Rev. <u>0</u>								
	2-Deburr if necessary								
110		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									
120		0.00							
	QC8- Inspect parts - second check								
QC	Memo	0.00							
Quality Control									

11-3-28

15

11-3-28

8/103/28

15

Work Order ID 67526

Monday, March 28, 2011 9:06:39 AM



Page 2

Item ID: D3319-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearplate

Start Date: 3/28/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 3/31/2011 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140



Brake NC

Brake NC

NC BRAKE

Memo

0.00

0.00

1- Form using DT8326 & DT8261 as per Dwg D3319Rev
2- Form flat on press using DT8776 block

150



QC

Quality Control

QC6- Inspect dimensions to drawing

0.00

Memo

0.00

160



Large Fab

Large Fab

Weld per dwg A/R Hardcoat steel Batch 11/17/39 0.00

Large Fab

Memo

0.00

1- Layout weld location as per Dwg D3319 using jig D3319-IT3
2- Weld hard surface using DT8755 per QSI 004 and Dwg D3319 Rev: B

Qty Part Number Description Batch

A/R N/A 228/7560 Hardcoat Rod 11/17/39

15

SB 11/03/29

45

EL 11-4-17 212

Work Order ID 67526

Monday, March 28, 2011 9:06:39 AM

Page 3

Item ID: D3319-1

Accept

Revision ID:

Item Name: Wearplate

Start Date: 3/28/2011 Start Qty: 12.00

Required Date: 3/31/2011 Req'd Qty: 12.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170

QC10- Inspect visual per QSI004- ground welds

0.00

QC

Memo

0.00

Quality Control

180

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

190

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

Powdercoat

Memo

0.00

Powder Coating

START TIME
OVEN TEMPERATURE:
FINISH TIME.

10:55
350
14:25

(412)

12 BR 11-4-12

Work Order ID 67526

Monday, March 28, 2011 9:06:39 AM



Page 4

Item ID: D3319-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearplate

Start Date: 3/28/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 3/31/2011 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date: ...

Tooling:

Date:

Stop



QC:

Date: ...

SPC (Y/N):

Date: ...

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

12 d 11/4/12

210

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify on inside surface using a permanent fine point marker with the following
TCCA-PDA, Dart Aerospace Ltd.
P/N: D3319-1, B/N: BXXXXX
For Product Eligibility see PDA05-18
and Stock Location. 197

11/4/12 D 12

220

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/12 D

11/5

11-04-12

Picklist Print

Monday, March 28, 2011 9:06:44 AM

Page 1

Work Order ID: 67526

Parent Item: D3319-1

Parent Item Name: Wearplate



Start Date: 3/28/2011

Required Date: 3/31/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP: B 05.10.14 Added step 9, dwg rev B KJ/EC
IPP Rev:C Now on Waterjet 06-10-26 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M1010S18GA

Purchased

No

100

sf

120.0000

0.628

7.932632

9.5



1811-3-28

1010/1025 SHEET .048

Location

Loc Qty

Loc Code

MAT019

120

116268

120

116268

15

SHOP COPY

RETURN TO

ENGINEERING

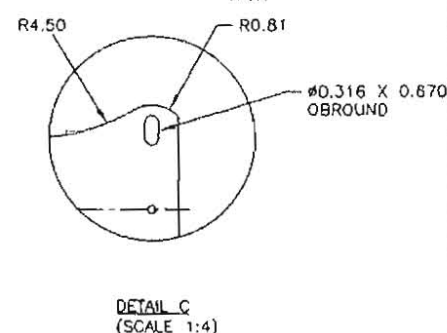
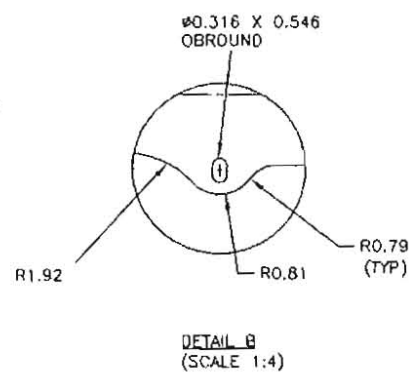
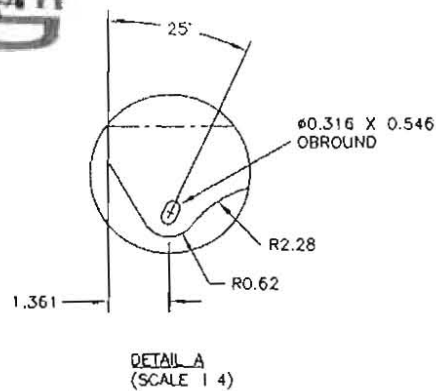
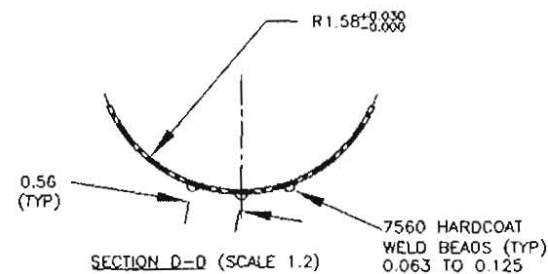
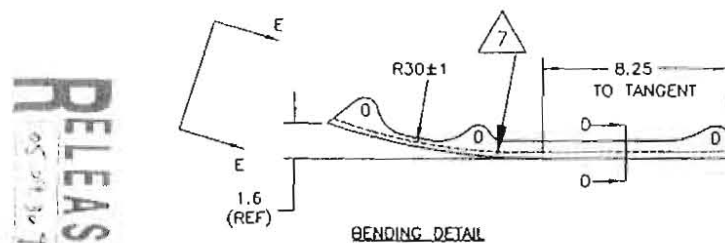
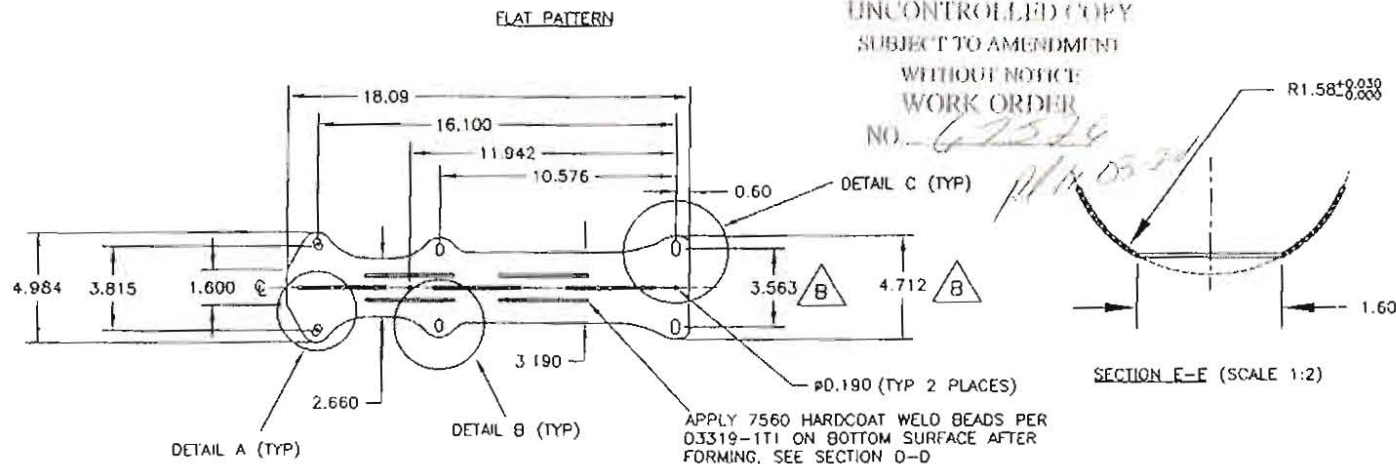
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SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 67524



03319-1 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
TCCA-PDA, DART AEROSPACE LTD., P/N 03319-1 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-18"

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD
041	041	HAMMERSBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
DATE	05.06.06	03319
05.06.06	04.09.24	WEARPLATE
A	05.06.06	NEW ISSUE
B		WIDEN HOLES, REDUCE WIDTH -3/-5/-7
		SCALE
		1:8

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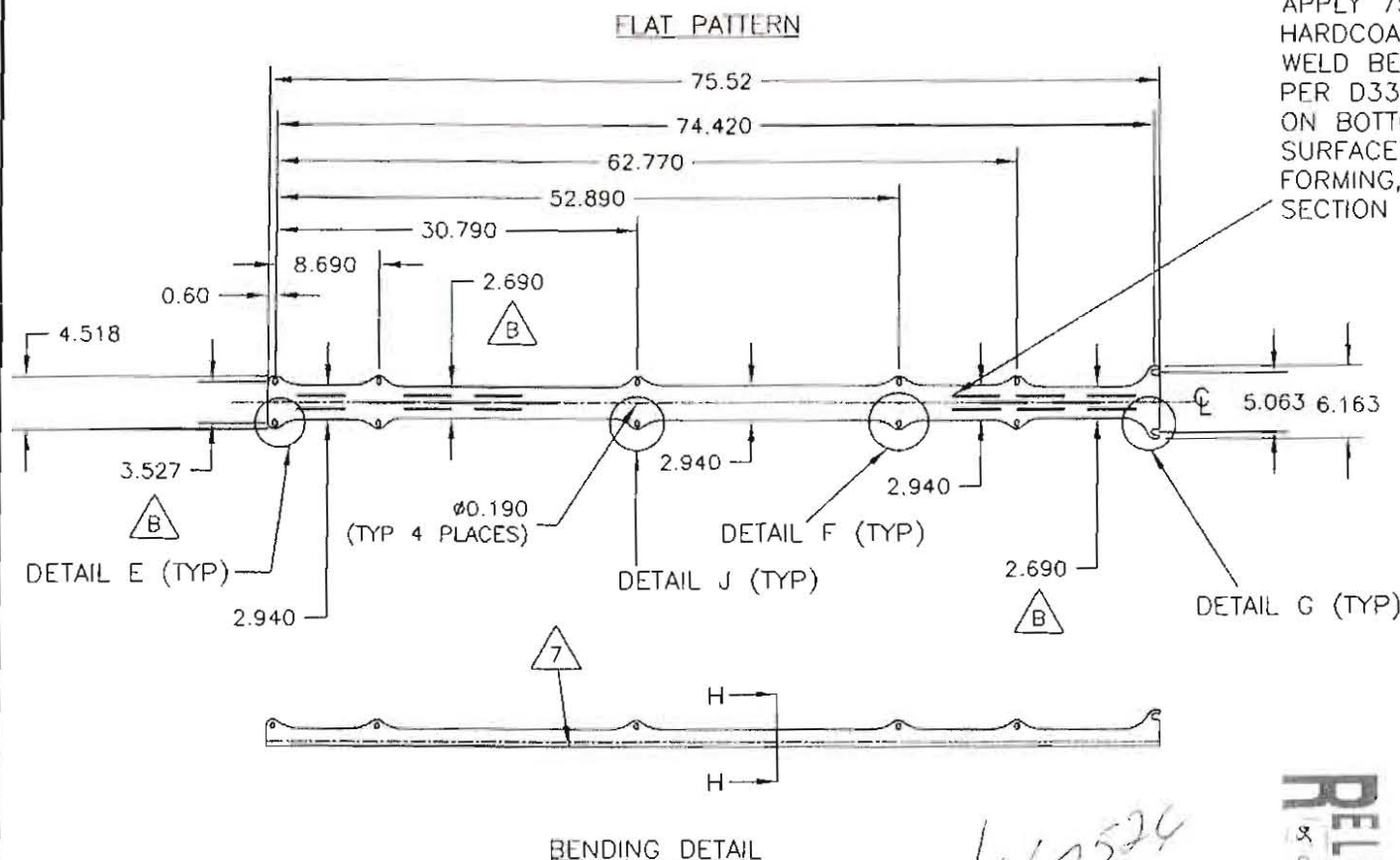
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RELEASED

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	DRAWING NO.	REV. B
05.06.06	D3319	SHEET 2 OF 5
	TITLE	SCALE
	WEARPLATE	1:15

APPLY 7560
HARDCOAT
WELD BEADS
PER D3319-3T1
ON BOTTOM
SURFACE AFTER
FORMING, SEE
SECTION H-H

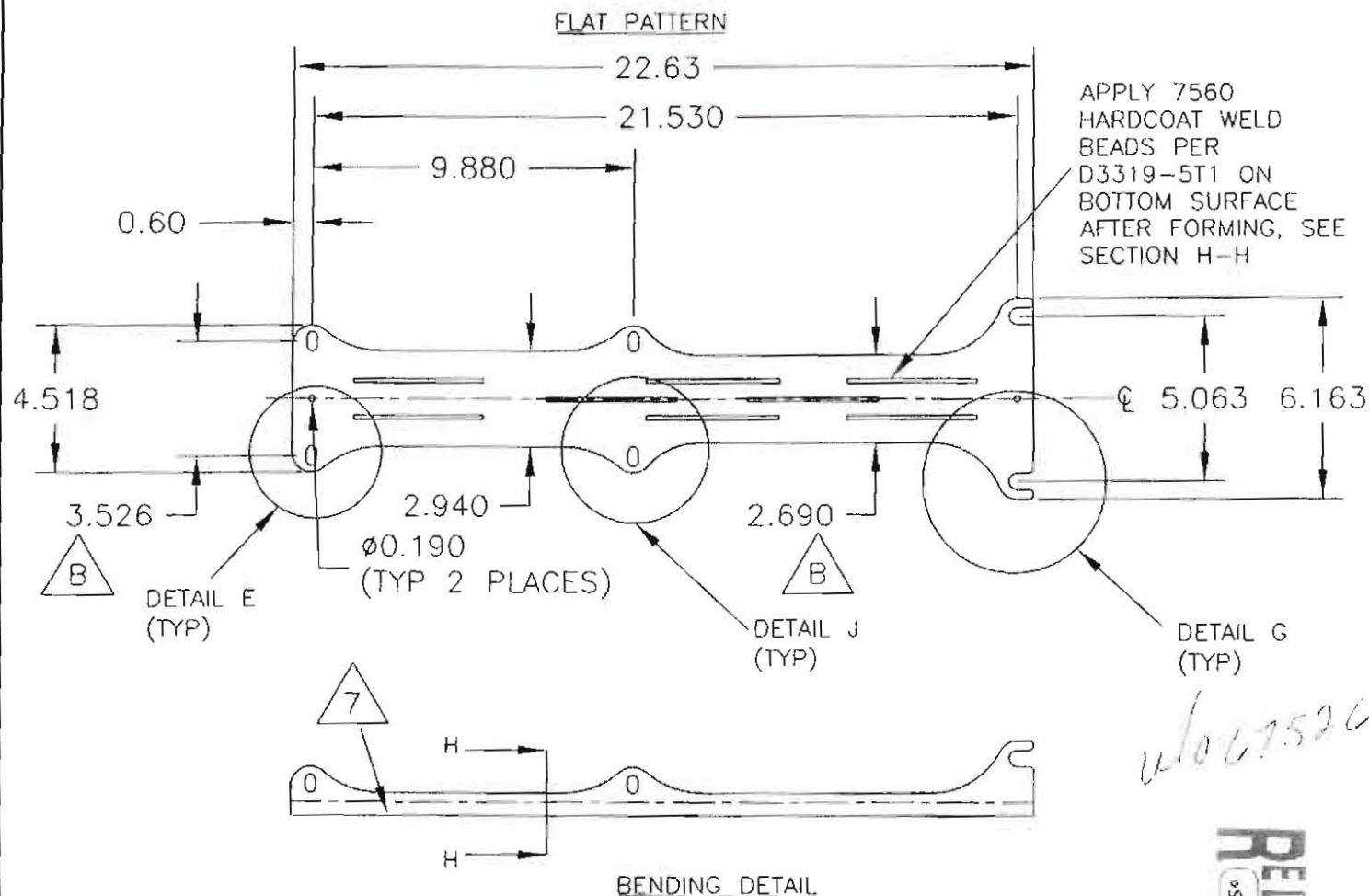


D3319-3 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-3 B/N BXXXXX,
FOR PRODUCT ELIGIBILITY SEE PDA05-18"

RELEASED
5 01 10 11

W/1067524

DART

D3319-5 WEARPLATE

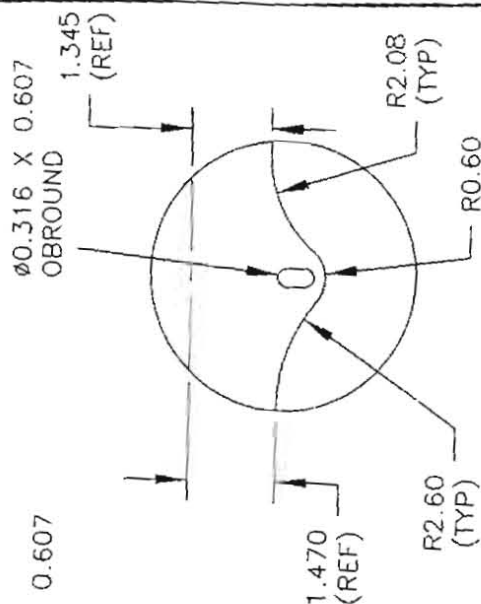
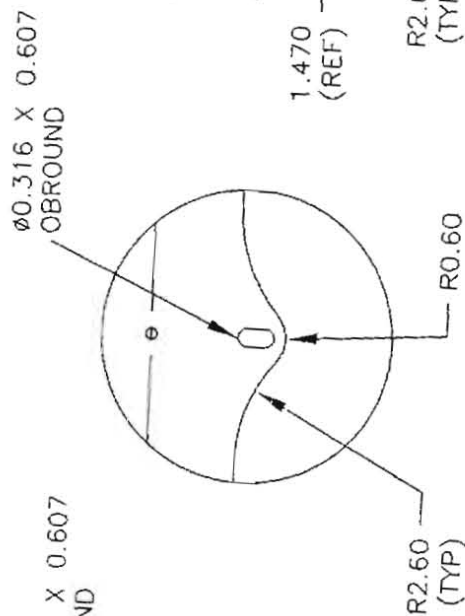
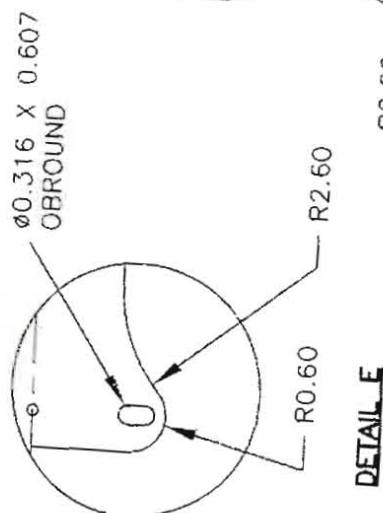
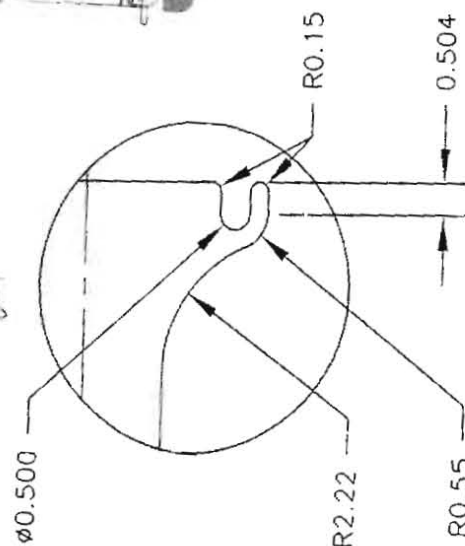
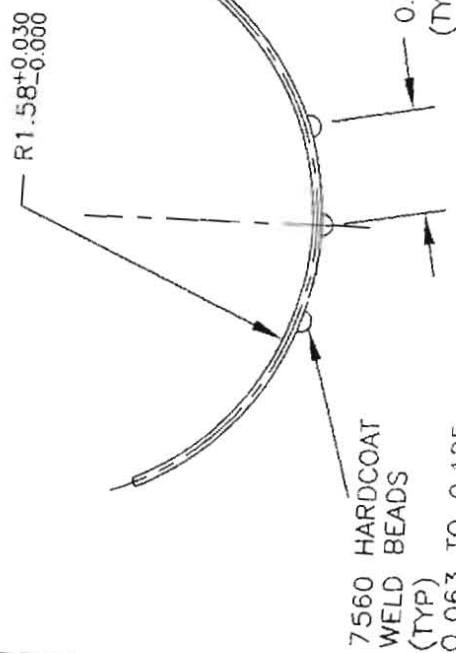
- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
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- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-5 B/N BXXXXX,
FOR PRODUCT ELIGIBILITY SEE PDA05-18"

DESIGN	DRAWN BY	DRAWING NO.	REV. B
021	021	D3319	SHEET 3 OF 5
CHECKED	APPROVED	TITLE	SCALE
05.06.06	05.06.06	WEARPLATE	1:5

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA**RELEASED**
05.06.06

DART

DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3319	REV. B SHEET 5 OF 5
DATE 05.06.06	TITLE WEARPLATE		SCALE 1:3

**DETAIL J****DETAIL F****DETAIL E****RELEASED**
05 09 30**DETAIL G****SECTION H-H
(SCALE 1:1)**